

76471

Page 1

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** M.L.J **Date:** 11/11/15 **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76471***76471***

Page 2

November-15-11 8:12:11 AM

Item ID: D3253-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Small Shelf
Start Date: 15/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 29/11/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

(3)

SB
12/05/30

3

12-05-30

3

24 12-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 76471

76471

Page 3

November-15-11 8:12:11 AM

Item ID: D3253-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Small Shelf
Start Date: 15/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 29/11/2011 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 1-30								
	FINISH TIME: 3200								
	OVEN TEMPERATURE: 2500								
170	QC3- Inspect Part Finish	0.00							
170									
QC		0.00							
Quality Control	Memo								
180	Identify as per dwg & Stock Location	0.00							
180									
Packaging		0.00							
Packaging	Memo								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

November-15-11 8:12:11 AM

76471

Page 4

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 15/11/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

Qty Qty Number Stamp
12/6/4 20
ms 12/06/0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November-15-11 8:12:17 AM

Page 1

Work Order ID: 76471

76471

Parent Item: D3253-1

D3253-1

Parent Item Name: Small Shelf

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B 04.10.26 D3253-1 no longer made in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

sf

33.5000

2.592

4,

M2024T3S 063

**

18125-30

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

33.5

117392

33.5

11996
~~11739~~

3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76471
Description: Small Shelf (Dual Battery Rack)		Part Number:	D3253-1
Inspection Dwg: D3253 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.289	+/-0.010	23.289	✓		T B01	
1.425	+/-0.010	1.427	2		V B02	
R0.19	+/-0.030	.19	2		R.G.	
0.697	+/-0.010	.697	✓		V	
6.502	+/-0.010	6.508	2		V	
5.200	+/-0.010	5.205	?		V	
1.300 Pitch	+/-0.010	1.300	2		V	
Ø0.098	+0.005/-0.000	.101	2		V	
0.300	+/-0.010	.301	✓		V	
R0.13	+/-0.030	.13			R.G.	
0.651	+/-0.010	.654	2		V	
0.643	+/-0.010	.640	?		V	
8.020	+/-0.010	8.030	2		V	
7.508	+/-0.010	7.505	✓		V	
R0.13	+/-0.030	.13	2		R.G.	
0.063	+/-0.005	.063	✓		V	
Grain along 23.289	N/A		✓			

Measured by: IB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12-5-30	Date: 12.05.30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue P/O D205-579-015	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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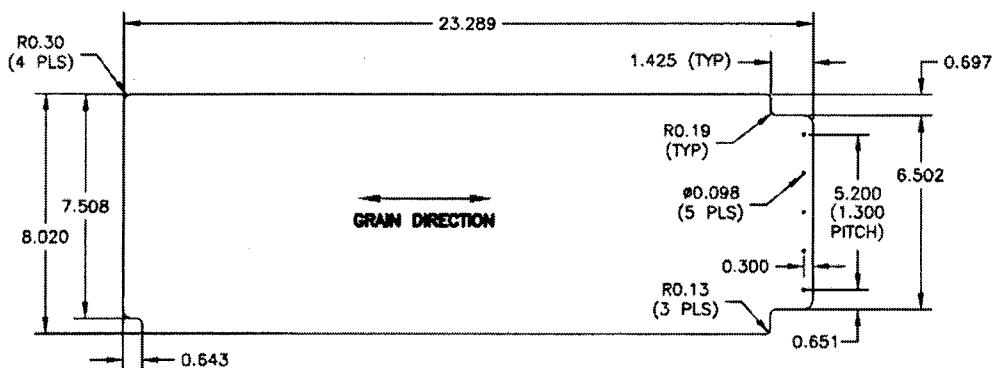
NOTE: Date & initial all entries



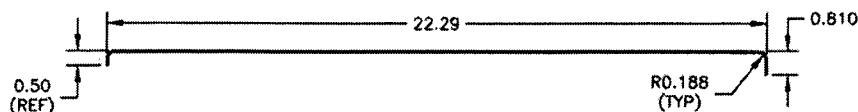
DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3253	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SMALL SHELF (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

RELEASED
04.05.04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76471 M.C.5
11/11/15



FLAT PATTERN



D3253-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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